

Date: Tuesday, 23/12/2008 12:53:32 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE, INBOARD, LS, 206
Job Number :	44284		
Estimate Number :	10820		
P.O. Number :		Part Number :	D26661
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2666 REV. D
First Issue :	/ /	Project Number :	N/A
Previous Run :	43852	Drawing Revision :	D
	Type :	Material :	
	MACHINED PARTS	Due Date :	09/01/2009
Written By :		Qty:	6
Checked & Approved By :		Um:	Each
Comment :	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: 334872 ml 08/12/30

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1- Inspect part number and batch number are programmed correctly.
 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 5- Deburr

ml 08/12/30

⑥

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

ml 09/01/05

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/12/30

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 44284

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/01/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JL

09-07-01

(X6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:10

OVEN TEMPERATURE:

320°

FINISH TIME:

9:40

FL 09/01/07

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-07-01 (X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 426

9/1/7

SQ

(PX)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

(6)

Job Completion



MF 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

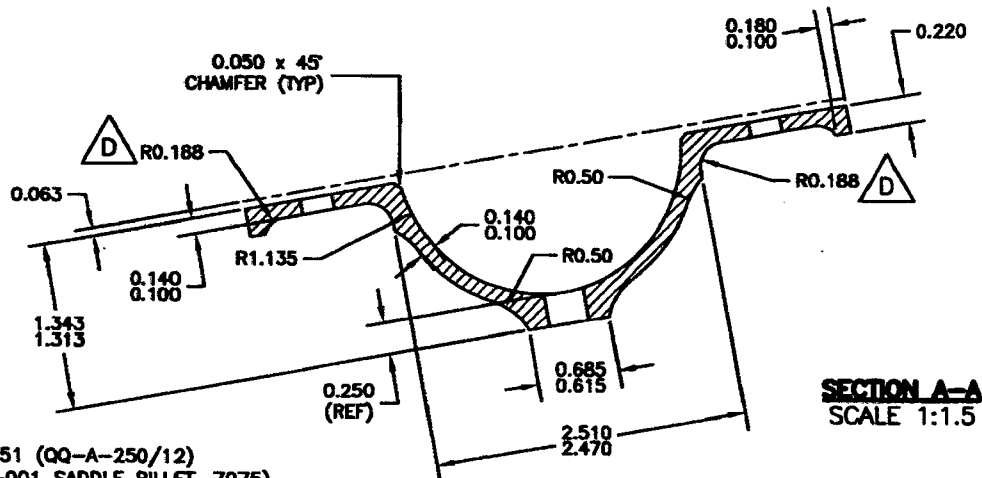
DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

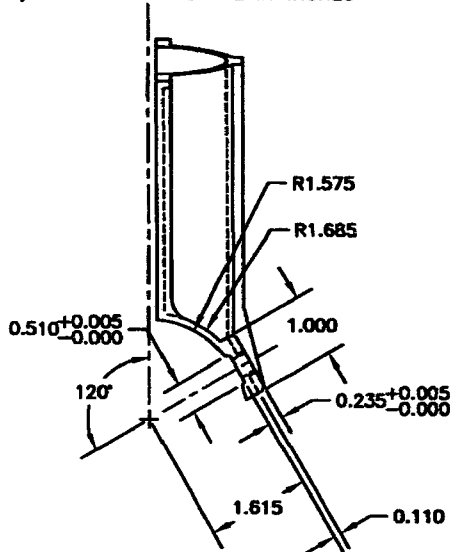
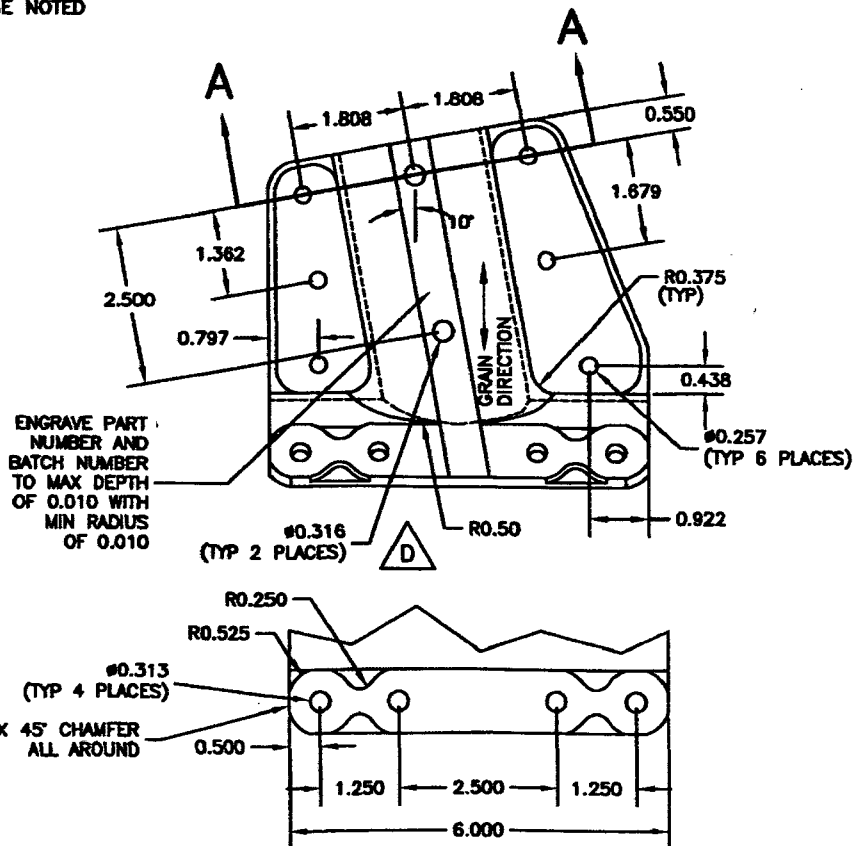
RELEASED

07.02.12

w/o 44284

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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DART AEROSPACE LTD		Work Order:	44284
Description: 206 Saddle, Inboard, Left side		Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.117	.118	.118		
B	0.100	0.140		.111	.111	.111	.111		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.223	.223	.223	.223		
F	1.313	1.343		1.326	1.326	1.326	1.324		
G	0.240	0.260		.247	.247	.247	.247		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.001	1.001	1.002	1.003		
K	0.235	0.240		.236	.236	.236	.236		
L	0.510	0.515		.510	.510	.511	.511		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.574	1.574	1.574	1.576		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.500	.498		
S	0.313	0.318		.315	.315	.315	.315		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.550	.549	.549		
X	1.674	1.684		1.681	1.681	1.680	1.680		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>ml</i>
Date:	08/12/31

Audited by:	J.L
Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.116				
B	0.100	0.140		.111	.111				
C	2.470	2.510		2.490	2.490				
D	0.100	0.180		.135	.140				
E	0.210	0.230		.223	.223				
F	1.313	1.343		1.328	1.328				
G	0.240	0.260		.248	.247				
H	0.615	0.685		.650	.650				
I	1.125	1.145		1.140	1.140				
J	0.990	1.010		1.002	1.002				
K	0.235	0.240		.236	.236				
L	0.510	0.515		.511	.511				
M	0.100	0.120		.110	.110				
N	1.565	1.585		1.574	1.574				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.502	.500				
S	0.313	0.318		.315	.315				
T	2.495	2.505		2.506	2.500				
U	1.357	1.367		1.363	1.363				
V	0.315	0.322		.321	.321				
W	0.540	0.560		.549	.548				
X	1.674	1.684		1.680	1.686				
Y	0.257	0.262		.259	.259				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>	Audited by:	JL
Date:	08/12/31	Date:	09/01/06

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